



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.7816

Job Sheet 205068



Part No: 647.7816

Job Qty: 8 pcs

Part Name: Aft Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/27/19

Job Tracking No:

Due Date: 3/30/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP REV A RQ VERIFIED BY DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	8 pcs	3/30/20		0.00	0.01	Bandsaw - 1		
110	HAAS 4 Axis - B4B	8 pcs	3/30/20		1.00	3.83	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	8 pcs	3/30/20		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		



Container No: S265362



Part: 647.7816

Job No: 205068

Serial No/Batch: S265362

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/20/20

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130	QC 8	8 pcs	3/30/20	0.00 0.00	QC 2 - 8			
					QC 2 - 66			
					QC 2 - 64			
					QC 2 - 65			
					QC 2 - 5			
					QC 2 - 71			
					QC 2 - 73			
					QC 2 - 69			
					QC 8 - 12			
					QC 8 - 14	7/20/03/24		
					QC 8 - 17			
					QC 8 - 20			
					QC 8 - 25			
					QC 8 - 3			
					QC 8 - 32			
					QC 8 - 33			
					QC 8 - 35			
					QC 8 - 39			
					QC 8 - 4			
					QC 8 - 44			
					QC 8 - 45			
					QC 8 - 49			
					QC 8 - 58			
					QC 8 - 8			
					QC 8 - 9			
QC 8 - 68								
QC 8 - 67								
QC 8 - 1 (A)								
QC 8 - 47								
QC 8 - 40								
QC 8 - 52								
QC 8 - 23								
QC 8 - 57								
QC 8 - 76								
QC 8 - 61								
140	Outsource - 4 - Anodize	8 pcs	3/30/20		ATG001-VC	5	2020-03-27	
150	Packaging 2-1 - Receive - B4B	8 pcs	3/30/20	0.00 0.00	Packaging 2 - 1 - B4B			
					Packaging 2 - 2 - B4B			
					Packaging 2 - 3 - B4B			
					Packaging 2 - 5 - B4B	APR 14 2020		
					Packaging 2 - 4 - B4B			
					Packaging 2 - 6 - B4B			
					Packaging 2 - 7 - B4B			
					Packaging 2 - 8 - B4B			
					Packaging 2 - 9 - B4B			
					Packaging 2 - 10 - B4B			
					Packaging 2 - 11 - B4B			
					Packaging 2 - 12 - B4B			
					Packaging 2 - 13 - B4B			
					Packaging 2 - 14 - B4B			
					Packaging 2 - 15 - B4B			
					Packaging 2 - 16 - B4B			
					Packaging 2 - 17 - B4B			
					Packaging 2 - 18 - B4B			
					Packaging 2 - 19 - B4B			
					Packaging 2 - 20 - B4B			
					Packaging 2 - 21 - B4B			
					Packaging 2 - 22 - B4B			
					Packaging 2 - 23 - B4B			
					Plex 12/27/19 1:02 PM		Dart.lajeunesse.marie	

				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				Packaging 2 - 37 - B4B	
160	QC 6	8 pcs	3/30/20	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40
					QC 6 - 81
180	Packaging 3-1 - Stock - B4B	8 pcs ✓	3/30/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B ✓
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
					Packaging 3 - 37 - B4B
190	QC 21 - SA	8 pcs ✓	3/30/20	0.00 0.00	QC 21 - SA - 21 ✓
					QC 21 - SA - 70
					QC 21 - SA - 53

Part Op 100 - (Bandsaw) Cut Blanks at 4.25"
 Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine per folio F312
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - Issue P/O to ATG: 46185 Hard Black Anodize and Prime as per Dwg 647.7800 Rev. A
 150 - (Receive & Inspect for Damage & Mat'l Certs)
 160 - (QC6- All purchased or subcontracted products)
 180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***
 190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6B1.500X1.500	7075 T6 Bar 1.500 X 1.500 see mat'l	2.8320 ft (.354 ea)	100-Bandsaw - 1	S255556
	M7075T6S1.500X1.500			

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M7075T6B1.500X1.500	3	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Aft Bracket	1.150Inches ± 0.005	1.155 1.145		1.148
2	Aft Bracket	0.170Inches ± 0.005	0.175 0.165		.169
3	Aft Bracket	0.170Inches ± 0.005	0.175 0.165		.169
4	Aft Bracket	34.400Degrees ± 0.500	34.900 33.900	Angle	34.5
5	Aft Bracket	0.320Inches ± 0.005	0.325 0.315	Radius	.32
6	Aft Bracket	0.830Inches ± 0.005	0.835 0.825		.83
7	Aft Bracket	45.400Degrees ± 0.500	45.900 44.900	Angle	45.5
8	Aft Bracket	0.272Inches ± 0.005	0.277 0.267	Radius	.27
9	Aft Bracket	0.753Inches ± 0.005	0.758 0.748		.75
10	Aft Bracket	4.048Inches ± 0.005	4.053 4.043		4.0495
11	Aft Bracket	2.400Degrees ± 0.500	2.900 1.900	Angle	2.2
12	Aft Bracket	0.247Inches ± 0.005	0.252 0.242	Radius	.25
13	Aft Bracket	0.527Inches ± 0.002	0.529 0.525		0.5269 S265
14	Aft Bracket	1.276Inches ± 0.002	1.278 1.274		1.2765
15	Aft Bracket	2.404Inches ± 0.002	2.406 2.402		2.4055
16	Aft Bracket	3.576Inches ± 0.002	3.578 3.574		3.577
17	Aft Bracket	0.666Inches ± 0.002	0.668 0.664		.667
18	Aft Bracket	0.631Inches ± 0.002	0.633 0.629		.631
19	Aft Bracket	0.578Inches ± 0.002	0.580 0.576		.577
20	Aft Bracket	0.573Inches ± 0.002	0.575 0.571		.572

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046185



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE STREET
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalonde, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB046185
PO Date: 3/26/20
Due Date: 4/10/20
Purchase Order Revision:
Revision Date:
Issued By: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	298291	649.5212	649.5200 Rev C	Bracket Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF- 23377 TYPE 1 CLASS N	Firmed - x4	-	4/10/20	4 pcs	0 pcs	4 pcs	\$10.81/pcs	\$43.24
2	205067	647.7815	647.7800 Rev A	Fwd Bracket : Various STC's Issue P/O to ATG : Hard Anodize, Color Black and Prime as Per Dwg. 647.7800 Rev. A	Firmed - x8	-	4/10/20	8 pcs	0 pcs	8 pcs	\$8.66/pcs	\$69.28
3	205068	647.7816	647.7800 Rev A	Aft Bracket : Various STC's Issue P/O to ATG : Hard Black Anodize and Prime as per Dwg 647.7800 Rev. A	Firmed - x8	-	4/10/20	8 pcs	0 pcs	8 pcs	\$8.66/pcs	\$69.28
4	205069	647.7817	647.7800 Rev A	Aft Bracket : Various STC's Issue P/O to ATG : Hard Black Anodize and Prime as per Dwg 647.7800 Rev. A	Firmed - x8	-	4/10/20	8 pcs	0 pcs	8 pcs	\$8.66/pcs	\$69.28

APR 14 2020

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APR 14 2020

DAS
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9-89

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Hawkesbury, ON
K6A 1K7
Canada

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PURCHASE ORDER

POHB046185



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	207809	RBT18635-11	RBT18635 Rev 2A	Receiver -Issue P/O to ATG -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed X8	-	4/10/20	8 pcs	0 pcs	8 pcs	\$8.62/pcs	\$68.96
APR 14 2020												
6	205065	647.7813	647.7800 Rev A	Center Plate, Lower : Various STC's Issue P/O to ATG : Hard Black Anodize and Prime as per Dwg. 647.7800 Rev. A	Firmed X6	-	4/10/20	8 pcs	0 pcs	8 pcs	\$10.56/pcs	\$84.48
APR 14 2020												
7	207098	D2224	D2224 Rev F	Rappel Anchor Assembly : Various STC's (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O: Red Anodize as per Dwg D2224 MIL-A-8625	Firmed X12	-	4/10/20	12 pcs	0 pcs	12 pcs	\$8.62/pcs	\$103.44
APR 14 2020												
8	207963	RBW6205G25831-3G	RBW6205G25831-3G Rev 1	Puller Assembly, Lever Outsource4 (Outsource process-Anodize per QSI017 4.1.10.1) -Issue P/O to GROUPE ALTECH; PO -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed X2	-	4/10/20	2 pcs	0 pcs	2 pcs	\$8.62/pcs	\$17.24
APR 14 2020												



Dart Aerospace Ltd.
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PURCHASE ORDER

POHB046185



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
9	205487	649.5214	649.5200 Rev C	Bracket Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF- 23377 TYPE 1 CLASS N	Firmed XII	-	4/10/20	11 pcs	0 pcs	11 pcs	\$10.81/pcs	\$118.91
Grand Total:												\$644.11

APR 14 2020

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Handwritten signature: Kimberley

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A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 919990

Date: 14-Apr-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

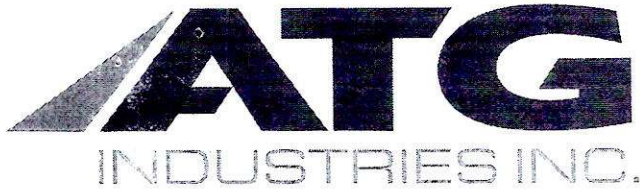
Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.			
4 ea	Part: 649.5212 Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot#: 123522 Job: 27306 PO: POHB046185	Rev: C	ASAP
3 ea	Part: 647.7815 Fwd Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot#: 123522 Job: 27307 PO: POHB046185	Rev: A	ASAP no rush
8 ea	Part: 647.7816 Aft Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot#: 123522 Job: 27308 PO: POHB046185	Rev: A	ASAP no rush DAS 31 1-89 RECEIVED APR 14 2020 DART AEROSPACE LTD.

Made in Canada.



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 919990

Date: 14-Apr-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

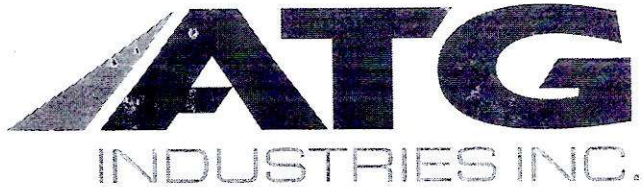
Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
8 ea	Part: 647.7817 Rev: A Aft Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot#: 122522 Expiry Date: 05/21 Job: 27309 Line: 4 PO: POHB046185		
8 ea	Part: 647.7813 Rev: A Center Plate, Lower Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot#: 122522 Expiry Date: 05/21 Job: 27311 Line: 6 PO: POHB046185		
11 ea	Part: 649.5214 Rev: C Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot#: 122522 Expiry Date: 05/21 Job: 27314 Line: 9 PO: POHB046185		
CERTIFICATE OF CONFORMANCE			
Made in Canada.			



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 919990

Date: 14-Apr-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms	Ship Via
	ATG Delivery
Quantity	Description
	A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>14/04/2020</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. Made in Canada.